

Date: Friday, 28/11/2008 2:54:21 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services			<b>Drawing Name</b>	: SADDLE, OUTBOARD, LH, 206		
<b>Job Number</b>	: 43851			<b>Part Number</b>	: D26651		
<b>Estimate Number</b>	: 10818			<b>Drawing Number</b>	: D2665 REV.D		
<b>P.O. Number</b>	:			<b>Project Number</b>	: N/A		
<b>This Issue</b>	: 28/11/2008	<b>S.O. No.</b>	:	<b>Drawing Revision</b>	: D		
<b>Prsh Rev.</b>	: NC			<b>Material</b>	:		
<b>First Issue</b>	: //	<b>Type</b>	: MACHINED PARTS	<b>Due Date</b>	: 20/12/2008	<b>Qty:</b>	6
<b>Previous Run</b>	: 41974			<b>Um:</b>	Each		
<b>Written By</b>	:						
<b>Checked &amp; Approved By</b>	<u>JUL 08-12-05</u>						
<b>Comment</b>	: Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC Est Rev:D As per Rev D 07-03-19 JLM						

## Additional Product

<b>Job Number:</b>				
<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>		
1.0	D6101003	Saddle Billet, 7075 		
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) 7075-T7351 2X6.25X7.875 Cut Size 2.0" x 6.25" x 7.88" Grain Along Long 7.88 Length Batch no <u>BS34873 x6</u> <u>mm= 08/12/22</u>  (6)				
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 		
<b>Comment:</b> HAAS CNC VERTICAL MACHINING #1 Program batch number. 1- Inspect part number and batch number are programmed correctly. 2- Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 3- Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet 4- Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet 5- Deburr <u>J.F. / mm= 08/12/22</u>  (6)				
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE 		
<b>Comment:</b> CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet <u>J.F. 08/12/22</u>  (6)				
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 		
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE <u>J.F. mm= 08/12/22</u>  (6)				

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 28/11/2008 2:54:21 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, LH, 206

Job Number: 43851

Part Number: D26651

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

JL 08/12/29

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(6X)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L 08/12/30

7.0 POWDER COATING

POWDER COATING



(6X)

M109996

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

11:00

START TIME:

320°F

OVEN TEMPERATURE:

11:30

FINISH TIME:

M-L 08/12/30

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(6)

Comment: INSPECT POWDER COAT

FL 08/12/30

9.0 PACKAGING 1

PACKAGING RESOURCE #1



(6x)

Comment: PACKAGING RESOURCE #1

SF

Identify and Stock

Location: 436

8/12/30

10.0 QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

10/09/08

Job Completion



MF 08-12-31

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order: 43851	
Description: 206 Saddle, Outboard, Left side			Part Number: D2665-1		
Inspection Dwg: D2665 Rev. D			Page 1 of 1		

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.109	.109"	.109"	.108"		
B	0.100	0.140		.128	.134"	.134"	.135"		
C	1.125	1.145		1.134	1.134"	1.136"	1.135"		
D	0.615	0.685		.663	.671"	.671"	.671"		
E	0.240	0.260		.247	.249"	.250"	.251"		
F	1.313	1.343		1.325	1.326"	1.326"	1.326"		
G	0.210	0.230		.219	.218"	.220"	.220"		
H	0.100	0.180		.134	.135"	.135"	.135"		
I	2.470	2.510		2.491	2.494"	2.494"	2.494"		
J	1.565	1.585		1.569	1.571"	1.573"	1.573"		
K	0.235	0.240		.236	.236"	.236"	.236"		
L	0.100	0.120		.110	.110"	.110"	.110"		
M	0.990	1.010		1.002	1.005"	1.005"	1.005"		
N	0.510	0.515		.510"	.510"	.510"	.510"		
O	5.990	6.010		6.000	5.998"	5.998"	5.998"		
P	1.245	1.255		1.248	1.250"	1.250"	1.250"		
Q	2.495	2.505		2.500	2.500"	2.500"	2.500"		
R	0.313	0.318		.315	.314"	.314"	.314"		
S	0.315	0.322		.317	.316"	.316"	.316"		
T	2.495	2.505		2.500	2.499"	2.499"	2.499"		
U	1.357	1.367		1.361	1.363"	1.363"	1.363"		
V	0.787	0.807		.798	.797"	.798"	.797"		
W	0.540	0.560		.546	.552"	.555"	.551"		
X	1.674	1.684		1.680	1.679"	1.681"	1.682"		
Y	0.257	0.262		.260	.259"	.259"	.259"		
Z	0.912	0.932		.920	.924"	.924"	.923"		
AA	0.490	0.510		.500	.502"	.502"	.502"		
AB	0.178	0.198		.187	R.188"	R.188"	R.188"		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	MJF	Audited by:	JL
Date:	08/12/22	Date:	08/12/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DS1 9095, DS1 9102 & DS1 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	SD

DART AEROSPACE LTD				Work Order:	43851
Description: 206 Saddle, Outboard, Left side				Part Number:	D2665-1
Inspection Dwg: D2665 Rev. D				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

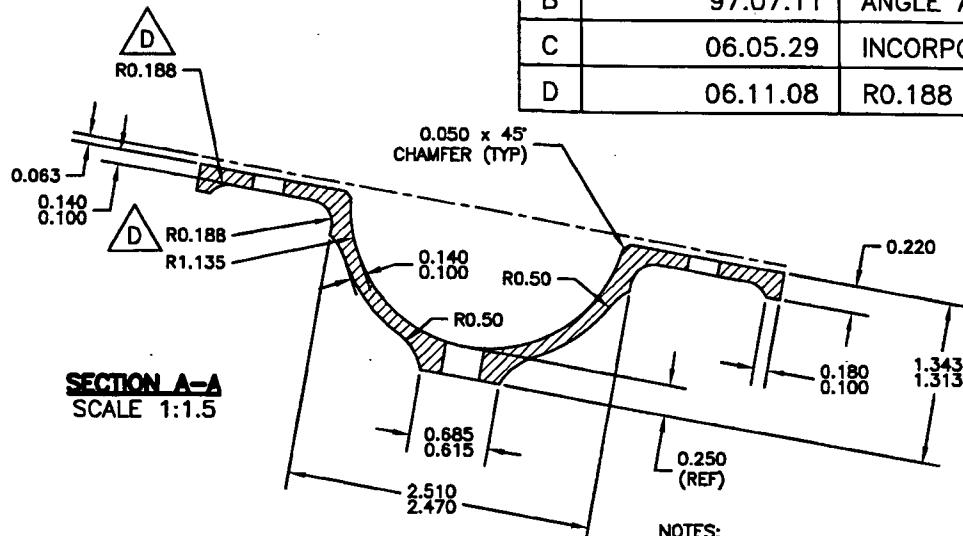
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.108"	.108"				
B	0.100	0.140		.135"	.131"				
C	1.125	1.145		1.136"	1.136"				
D	0.615	0.685		.671"	.671"				
E	0.240	0.260		.249"	.249"				
F	1.313	1.343		1.326"	1.326"				
G	0.210	0.230		.219"	.220"				
H	0.100	0.180		.135"	.135"				
I	2.470	2.510		2.494"	2.494"				
J	1.565	1.585		1.574"	1.575"				
K	0.235	0.240		.236"	.236"				
L	0.100	0.120		.110"	.110"				
M	0.990	1.010		1.005"	1.006"				
N	0.510	0.515		.510"	.510"				
O	5.990	6.010		5.998"	5.998"				
P	1.245	1.255		1.250"	1.251"				
Q	2.495	2.505		2.501"	2.500"				
R	0.313	0.318		.314"	.314"				
S	0.315	0.322		.316"	.316"				
T	2.495	2.505		2.500"	2.499"				
U	1.357	1.367		1.365"	1.362"				
V	0.787	0.807		.797"	.797"				
W	0.540	0.560		.550"	.550"				
X	1.674	1.684		1.680"	1.681"				
Y	0.257	0.262		.259"	.259"				
Z	0.912	0.932		.924"	.924"				
AA	0.490	0.510		.501"	.501"				
AB	0.178	0.198		.188"	.188"				
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	J.F.	Audited by:	SL
Date:	08/12/27	Date:	08/12/29

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

**DART**

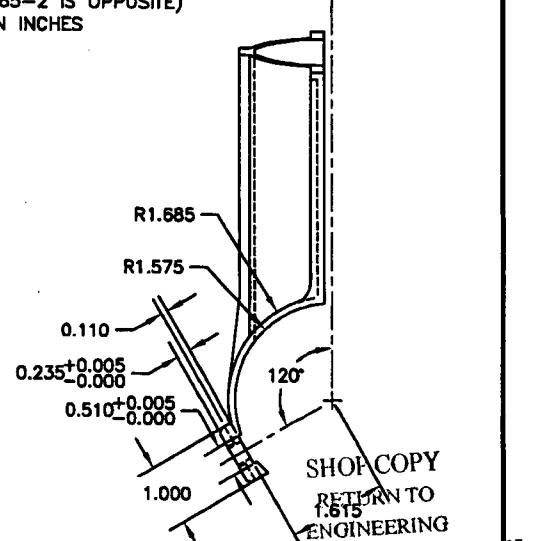
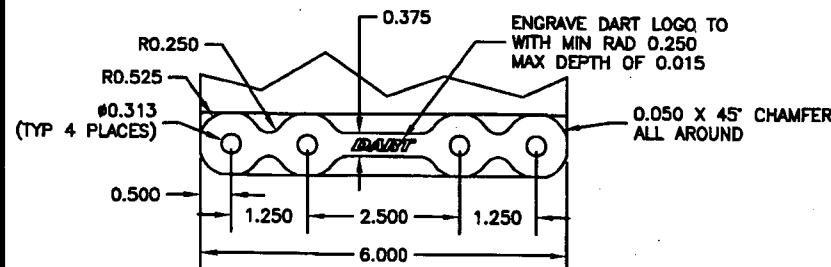
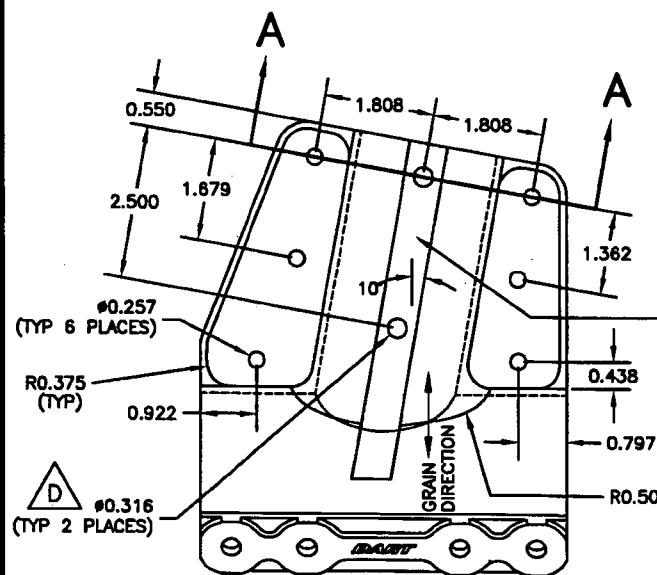
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2665
PH	CH	REV. D
DATE	TITLE	SCALE
06.11.08	SADDLE FWD OUTSIDE HIGH	1:3
A	97.03.25	NEW ISSUE
B	97.07.11	ANGLE AND NOTES ADDED
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313



SECTION A-A  
SCALE 1:1.5

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



**D2665-1 SADDLE FWD OUTSIDE HIGH 43851**